

# CHEMICAL SYNTHESIS OPTIMIZATION

## THE QUEST FOR EFFICIENCY: A COMPREHENSIVE GUIDE TO CHEMICAL SYNTHESIS OPTIMIZATION

**CHEMICAL SYNTHESIS OPTIMIZATION** IS A CORNERSTONE OF MODERN CHEMISTRY, DRIVING INNOVATION AND EFFICIENCY ACROSS DIVERSE INDUSTRIES FROM PHARMACEUTICALS TO MATERIALS SCIENCE. THIS INTRICATE PROCESS INVOLVES FINE-TUNING REACTION CONDITIONS, SELECTING OPTIMAL REAGENTS, AND STREAMLINING PURIFICATION METHODS TO ACHIEVE DESIRED CHEMICAL COMPOUNDS WITH MAXIMUM YIELD, PURITY, AND MINIMAL WASTE. ACHIEVING PEAK PERFORMANCE IN CHEMICAL SYNTHESIS IS NOT MERELY AN ACADEMIC PURSUIT; IT TRANSLATES DIRECTLY INTO REDUCED PRODUCTION COSTS, FASTER DEVELOPMENT CYCLES, AND A MORE SUSTAINABLE CHEMICAL ENTERPRISE. THIS ARTICLE DELVES INTO THE MULTIFACETED WORLD OF CHEMICAL SYNTHESIS OPTIMIZATION, EXPLORING ITS KEY PRINCIPLES, METHODOLOGIES, AND THE TRANSFORMATIVE IMPACT IT HAS ON SCIENTIFIC AND INDUSTRIAL PROGRESS. WE WILL EXAMINE THE CRITICAL FACTORS INFLUENCING REACTION OUTCOMES, DISCUSS VARIOUS ANALYTICAL AND COMPUTATIONAL TOOLS EMPLOYED FOR ENHANCEMENT, AND HIGHLIGHT THE ULTIMATE BENEFITS OF A WELL-OPTIMIZED SYNTHETIC ROUTE.

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## UNDERSTANDING THE CORE PRINCIPLES OF CHEMICAL SYNTHESIS OPTIMIZATION

AT ITS HEART, CHEMICAL SYNTHESIS OPTIMIZATION IS ABOUT CONTROLLING CHEMICAL TRANSFORMATIONS TO ACHIEVE THE MOST FAVORABLE OUTCOME. THIS INVOLVES A SYSTEMATIC APPROACH TO IDENTIFY AND MANIPULATE VARIABLES THAT INFLUENCE THE RATE, SELECTIVITY, AND YIELD OF A CHEMICAL REACTION. THE ULTIMATE GOAL IS TO DEVELOP A ROBUST AND REPRODUCIBLE SYNTHETIC PROCESS THAT MEETS SPECIFIC CRITERIA, WHETHER IT'S PRODUCING A LIFE-SAVING DRUG OR A NOVEL MATERIAL WITH UNIQUE PROPERTIES. IT MOVES BEYOND SIMPLY DEMONSTRATING THAT A REACTION CAN OCCUR TO ENSURING IT OCCURS IN THE MOST EFFICIENT, COST-EFFECTIVE, AND ENVIRONMENTALLY CONSCIOUS MANNER POSSIBLE.

THE PURSUIT OF OPTIMIZATION IS DRIVEN BY A DEEP UNDERSTANDING OF REACTION MECHANISMS, KINETICS, AND THERMODYNAMICS. CHEMISTS AIM TO UNDERSTAND THE INTRICATE DANCE OF MOLECULES, IDENTIFYING RATE-LIMITING STEPS, POTENTIAL SIDE REACTIONS, AND EQUILIBRIUM LIMITATIONS. BY GAINING THIS FUNDAMENTAL INSIGHT, THEY CAN THEN STRATEGICALLY INTERVENE TO STEER THE REACTION TOWARDS THE DESIRED PRODUCT, MINIMIZING THE FORMATION OF UNWANTED BYPRODUCTS AND MAXIMIZING THE CONVERSION OF STARTING MATERIALS.

## KEY PARAMETERS FOR OPTIMIZING CHEMICAL REACTIONS

SEVERAL CRITICAL PARAMETERS CAN BE ADJUSTED TO ACHIEVE SUPERIOR RESULTS IN CHEMICAL SYNTHESIS. EACH PARAMETER PLAYS A VITAL ROLE, AND THEIR INTERPLAY IS OFTEN COMPLEX, REQUIRING CAREFUL CONSIDERATION AND EXPERIMENTATION. UNDERSTANDING THESE VARIABLES IS THE FIRST STEP IN DESIGNING AN EFFECTIVE OPTIMIZATION STRATEGY.

### TEMPERATURE CONTROL

TEMPERATURE PROFOUNDLY INFLUENCES REACTION KINETICS AND THERMODYNAMICS. INCREASING TEMPERATURE GENERALLY

ACCELERATES REACTION RATES BY PROVIDING MOLECULES WITH MORE KINETIC ENERGY, LEADING TO MORE FREQUENT AND ENERGETIC COLLISIONS. HOWEVER, EXCESSIVELY HIGH TEMPERATURES CAN ALSO PROMOTE UNWANTED SIDE REACTIONS, DECOMPOSITION OF REACTANTS OR PRODUCTS, AND REDUCE SELECTIVITY. CONVERSELY, LOWER TEMPERATURES MIGHT ENHANCE SELECTIVITY BY FAVORING THE DESIRED REACTION PATHWAY OVER COMPETING ONES, BUT AT THE COST OF SLOWER REACTION RATES. FINDING THE OPTIMAL TEMPERATURE IS A DELICATE BALANCE THAT DEPENDS HEAVILY ON THE SPECIFIC REACTION SYSTEM.

## CONCENTRATION AND STOICHIOMETRY

THE CONCENTRATION OF REACTANTS AND THE PRECISE STOICHIOMETRIC RATIOS IN WHICH THEY ARE COMBINED ARE CRUCIAL. DEVIATIONS FROM IDEAL STOICHIOMETRY CAN LEAD TO INCOMPLETE REACTIONS OR THE CONSUMPTION OF EXPENSIVE REAGENTS IN SIDE REACTIONS. HIGH CONCENTRATIONS CAN SOMETIMES INCREASE REACTION RATES DUE TO MORE FREQUENT COLLISIONS, BUT THEY CAN ALSO LEAD TO SOLUBILITY ISSUES, INCREASED VISCOSITY, OR EXOTHERMIC REACTIONS THAT ARE DIFFICULT TO CONTROL. DILUTION, ON THE OTHER HAND, CAN SOMETIMES IMPROVE SELECTIVITY OR MANAGE HEAT DISSIPATION BUT AT THE EXPENSE OF SLOWER KINETICS AND LARGER REACTION VOLUMES.

## SOLVENT SELECTION

THE CHOICE OF SOLVENT IS A CRITICAL FACTOR THAT INFLUENCES SOLUBILITY OF REACTANTS AND PRODUCTS, REACTION RATE, SELECTIVITY, AND EASE OF WORK-UP AND PURIFICATION. SOLVENTS CAN PARTICIPATE IN REACTIONS AS REACTANTS OR CATALYSTS, OR THEY CAN SIMPLY PROVIDE A MEDIUM FOR THE REACTION TO OCCUR. POLAR PROTIC SOLVENTS, POLAR APROTIC SOLVENTS, AND NONPOLAR SOLVENTS EACH HAVE DISTINCT EFFECTS ON REACTION MECHANISMS AND OUTCOMES. AN OPTIMAL SOLVENT SYSTEM WILL SOLUBILIZE REACTANTS SUFFICIENTLY, PROMOTE THE DESIRED REACTION PATHWAY, AND BE EASY TO REMOVE OR RECYCLE.

## CATALYST CHOICE AND LOADING

CATALYSTS ARE SUBSTANCES THAT INCREASE THE RATE OF A CHEMICAL REACTION WITHOUT BEING CONSUMED IN THE PROCESS. THE SELECTION OF AN APPROPRIATE CATALYST IS PARAMOUNT FOR MANY SYNTHETIC TRANSFORMATIONS. DIFFERENT CATALYSTS CAN DRAMATICALLY ALTER REACTION PATHWAYS, LEADING TO DIFFERENT PRODUCTS OR IMPROVED SELECTIVITY. THE AMOUNT OF CATALYST USED, KNOWN AS CATALYST LOADING, ALSO NEEDS OPTIMIZATION. TOO LITTLE CATALYST WILL RESULT IN SLOW REACTION RATES, WHILE TOO MUCH CAN BE ECONOMICALLY WASTEFUL OR EVEN DETRIMENTAL TO THE REACTION OUTCOME.

## REACTION TIME

THE DURATION FOR WHICH A REACTION IS ALLOWED TO PROCEED DIRECTLY IMPACTS THE CONVERSION OF REACTANTS TO PRODUCTS. OPTIMIZING REACTION TIME INVOLVES ALLOWING SUFFICIENT TIME FOR THE REACTION TO REACH COMPLETION OR ITS OPTIMAL POINT WITHOUT ALLOWING SIGNIFICANT DEGRADATION OF PRODUCTS OR THE FORMATION OF UNDESIRABLE BYPRODUCTS OVER EXTENDED PERIODS. MONITORING THE REACTION PROGRESS OVER TIME IS ESSENTIAL TO DETERMINE THE IDEAL ENDPOINT.

## pH CONTROL

FOR REACTIONS INVOLVING ACIDS OR BASES, PRECISE pH CONTROL IS OFTEN INDISPENSABLE. pH CAN INFLUENCE THE IONIZATION STATE OF REACTANTS AND INTERMEDIATES, THEREBY AFFECTING THEIR REACTIVITY AND SELECTIVITY. MAINTAINING THE CORRECT pH CAN BE CRITICAL FOR STABILIZING SENSITIVE MOLECULES, FACILITATING SPECIFIC PROTON TRANSFER EVENTS, OR ENSURING THE CATALYTIC ACTIVITY OF A PARTICULAR SPECIES.

# METHODOLOGIES AND TOOLS FOR SYNTHESIS OPTIMIZATION

THE SYSTEMATIC OPTIMIZATION OF CHEMICAL SYNTHESIS RELIES ON A COMBINATION OF EXPERIMENTAL TECHNIQUES AND COMPUTATIONAL APPROACHES. THESE METHODOLOGIES ALLOW CHEMISTS TO EFFICIENTLY EXPLORE THE VAST PARAMETER SPACE AND IDENTIFY OPTIMAL CONDITIONS.

## DESIGN OF EXPERIMENTS (DoE)

DESIGN OF EXPERIMENTS (DoE) IS A STATISTICAL APPROACH THAT ENABLES EFFICIENT EXPLORATION OF MULTIPLE REACTION PARAMETERS SIMULTANEOUSLY. INSTEAD OF VARYING ONE PARAMETER AT A TIME, DoE DESIGNS ALLOW FOR THE SIMULTANEOUS INVESTIGATION OF SEVERAL FACTORS AND THEIR INTERACTIONS, LEADING TO A MORE COMPREHENSIVE UNDERSTANDING OF THE REACTION LANDSCAPE AND SIGNIFICANTLY REDUCING THE NUMBER OF EXPERIMENTS REQUIRED. COMMON DoE METHODOLOGIES INCLUDE FACTORIAL DESIGNS, FRACTIONAL FACTORIAL DESIGNS, AND RESPONSE SURFACE METHODOLOGY.

## HIGH-THROUGHPUT EXPERIMENTATION (HTE)

HIGH-THROUGHPUT EXPERIMENTATION (HTE) UTILIZES AUTOMATED SYSTEMS TO PERFORM A LARGE NUMBER OF EXPERIMENTS IN PARALLEL UNDER VARYING CONDITIONS. THIS APPROACH IS PARTICULARLY VALUABLE FOR SCREENING A WIDE RANGE OF CATALYSTS, SOLVENTS, OR REAGENT COMBINATIONS QUICKLY. COUPLED WITH MINIATURIZATION AND ROBOTIC HANDLING, HTE ALLOWS FOR RAPID IDENTIFICATION OF PROMISING REACTION CONDITIONS THAT CAN THEN BE FURTHER REFINED USING MORE TRADITIONAL METHODS.

## ANALYTICAL TECHNIQUES FOR MONITORING AND CHARACTERIZATION

EFFECTIVE OPTIMIZATION IS IMPOSSIBLE WITHOUT ROBUST ANALYTICAL TOOLS TO MONITOR REACTION PROGRESS AND CHARACTERIZE THE PRODUCT. TECHNIQUES SUCH AS THIN LAYER CHROMATOGRAPHY (TLC), GAS CHROMATOGRAPHY (GC), HIGH-PERFORMANCE LIQUID CHROMATOGRAPHY (HPLC), AND NUCLEAR MAGNETIC RESONANCE (NMR) SPECTROSCOPY ARE INDISPENSABLE FOR DETERMINING CONVERSION, SELECTIVITY, AND PURITY. SPECTROSCOPIC METHODS LIKE INFRARED (IR) AND MASS SPECTROMETRY (MS) AID IN IDENTIFYING AND CONFIRMING THE STRUCTURE OF THE DESIRED PRODUCT AND ANY BYPRODUCTS.

## PROCESS ANALYTICAL TECHNOLOGY (PAT)

PROCESS ANALYTICAL TECHNOLOGY (PAT) INVOLVES REAL-TIME MONITORING AND CONTROL OF MANUFACTURING PROCESSES. IN CHEMICAL SYNTHESIS, PAT CAN INTEGRATE ANALYTICAL TOOLS DIRECTLY INTO THE REACTION VESSEL OR FLOW STREAM, PROVIDING CONTINUOUS DATA ON CRITICAL PROCESS PARAMETERS. THIS ALLOWS FOR IMMEDIATE ADJUSTMENTS TO BE MADE TO MAINTAIN OPTIMAL CONDITIONS, PREVENT DEVIATIONS, AND ENSURE CONSISTENT PRODUCT QUALITY, MOVING FROM A BATCH-WISE OPTIMIZATION TO A CONTINUOUS IMPROVEMENT PARADIGM.

## ADVANCED TECHNIQUES IN CHEMICAL SYNTHESIS OPTIMIZATION

BEYOND THE FOUNDATIONAL PARAMETERS AND METHODOLOGIES, ADVANCED TECHNIQUES ARE INCREASINGLY EMPLOYED TO TACKLE COMPLEX OPTIMIZATION CHALLENGES AND PUSH THE BOUNDARIES OF SYNTHETIC EFFICIENCY.

## FLOW CHEMISTRY

FLOW CHEMISTRY, ALSO KNOWN AS CONTINUOUS FLOW SYNTHESIS, INVOLVES CONDUCTING CHEMICAL REACTIONS IN CONTINUOUS STREAMS RATHER THAN IN BATCH REACTORS. THIS METHOD OFFERS SIGNIFICANT ADVANTAGES FOR OPTIMIZATION, INCLUDING SUPERIOR HEAT AND MASS TRANSFER, PRECISE CONTROL OVER REACTION TIMES, AND ENHANCED SAFETY FOR EXOTHERMIC OR HAZARDOUS REACTIONS. THE ABILITY TO RAPIDLY CHANGE CONDITIONS AND SCALE UP PRODUCTION BY RUNNING THE FLOW REACTOR FOR LONGER DURATIONS MAKES IT AN ATTRACTIVE PLATFORM FOR OPTIMIZATION.

## CHEMINFORMATICS AND MACHINE LEARNING

THE ADVENT OF CHEMINFORMATICS AND MACHINE LEARNING HAS OPENED NEW AVENUES FOR PREDICTING AND OPTIMIZING CHEMICAL REACTIONS. BY ANALYZING VAST DATASETS OF PREVIOUSLY PERFORMED REACTIONS, MACHINE LEARNING ALGORITHMS CAN IDENTIFY PATTERNS AND PREDICT OPTIMAL CONDITIONS FOR NEW SYNTHETIC TARGETS. THIS DATA-DRIVEN APPROACH CAN SIGNIFICANTLY ACCELERATE THE OPTIMIZATION PROCESS, SUGGESTING PROMISING STARTING POINTS AND REDUCING THE NEED FOR EXTENSIVE EXPERIMENTAL SCREENING.

## COMPUTATIONAL CHEMISTRY AND MOLECULAR MODELING

COMPUTATIONAL CHEMISTRY TOOLS, SUCH AS DENSITY FUNCTIONAL THEORY (DFT), CAN BE USED TO MODEL REACTION MECHANISMS, CALCULATE ACTIVATION ENERGIES, AND PREDICT THE RELATIVE STABILITY OF INTERMEDIATES AND TRANSITION STATES. THIS THEORETICAL INSIGHT CAN GUIDE EXPERIMENTALISTS IN UNDERSTANDING WHY CERTAIN CONDITIONS FAVOR A PARTICULAR OUTCOME AND IN DESIGNING NEW STRATEGIES FOR OPTIMIZATION, PROVIDING A DEEPER UNDERSTANDING OF THE UNDERLYING CHEMICAL PRINCIPLES.

## GREEN CHEMISTRY PRINCIPLES IN OPTIMIZATION

MODERN CHEMICAL SYNTHESIS OPTIMIZATION INCREASINGLY INCORPORATES THE PRINCIPLES OF GREEN CHEMISTRY. THIS INVOLVES NOT ONLY MAXIMIZING YIELD AND PURITY BUT ALSO MINIMIZING WASTE, USING LESS HAZARDOUS REAGENTS AND SOLVENTS, AND REDUCING ENERGY CONSUMPTION. AN OPTIMIZED GREEN SYNTHETIC ROUTE IS ONE THAT IS BOTH SCIENTIFICALLY SOUND AND ENVIRONMENTALLY RESPONSIBLE, LEADING TO MORE SUSTAINABLE CHEMICAL PROCESSES.

## BENEFITS OF CHEMICAL SYNTHESIS OPTIMIZATION

THE IMPACT OF EFFECTIVE CHEMICAL SYNTHESIS OPTIMIZATION IS FAR-REACHING, PROVIDING TANGIBLE BENEFITS ACROSS SCIENTIFIC RESEARCH AND INDUSTRIAL APPLICATIONS.

### INCREASED YIELD AND PURITY

THE MOST DIRECT BENEFIT OF OPTIMIZATION IS A SIGNIFICANT IMPROVEMENT IN THE YIELD OF THE DESIRED PRODUCT AND ITS PURITY. HIGHER YIELDS MEAN MORE PRODUCT IS OBTAINED FROM THE SAME AMOUNT OF STARTING MATERIALS, DIRECTLY IMPACTING EFFICIENCY AND COST-EFFECTIVENESS. ENHANCED PURITY REDUCES THE NEED FOR EXTENSIVE AND COSTLY PURIFICATION STEPS, SAVING TIME AND RESOURCES.

## REDUCED COSTS

By maximizing yield, minimizing waste, and potentially using less expensive reagents or shorter reaction times, chemical synthesis optimization leads to substantial cost reductions in production. This is particularly critical in large-scale industrial manufacturing where even small improvements can translate into millions of dollars saved.

## FASTER DEVELOPMENT CYCLES

A well-optimized synthetic route allows for quicker progression from laboratory discovery to pilot-scale and full-scale production. This accelerates the development of new drugs, materials, and other chemical products, enabling companies to bring innovations to market faster.

## ENVIRONMENTAL SUSTAINABILITY

Optimizing chemical synthesis often involves reducing the generation of hazardous waste, using more benign solvents, and improving energy efficiency, all of which contribute to a more sustainable chemical industry. This aligns with global efforts to reduce environmental impact and promote eco-friendly manufacturing practices.

## ENHANCED SAFETY

By understanding and controlling reaction parameters, chemists can identify and mitigate potential safety hazards associated with chemical processes. Optimized reactions are often more predictable and less prone to runaway exothermic events or the formation of dangerous intermediates, leading to safer working environments.

## CHALLENGES AND FUTURE DIRECTIONS IN OPTIMIZATION

Despite significant advancements, chemical synthesis optimization continues to present challenges and evolve with new scientific discoveries. The complexity of chemical reactions, especially in multi-step syntheses, means that optimizing one step might negatively impact another. The sheer volume of potential reaction conditions and variables can be overwhelming. Furthermore, scaling up a reaction from the lab to industrial production often introduces new challenges related to heat and mass transfer that were not apparent at smaller scales.

The future of chemical synthesis optimization lies in the continued integration of artificial intelligence and machine learning, enabling predictive modeling and autonomous experimentation. Advances in automation and robotics will further accelerate the screening and optimization process. There will also be a sustained focus on developing highly selective and efficient catalytic systems, including biocatalysis, and on designing truly sustainable and circular chemical processes. The ongoing quest for optimization will undoubtedly continue to drive innovation and shape the future of chemistry.

## FREQUENTLY ASKED QUESTIONS

## **Q: WHAT IS THE PRIMARY GOAL OF CHEMICAL SYNTHESIS OPTIMIZATION?**

A: THE PRIMARY GOAL OF CHEMICAL SYNTHESIS OPTIMIZATION IS TO FINE-TUNE REACTION CONDITIONS AND PROCEDURES TO ACHIEVE THE HIGHEST POSSIBLE YIELD AND PURITY OF A DESIRED CHEMICAL COMPOUND WHILE MINIMIZING COSTS, WASTE, AND REACTION TIME.

## **Q: HOW DOES TEMPERATURE AFFECT CHEMICAL SYNTHESIS OPTIMIZATION?**

A: TEMPERATURE SIGNIFICANTLY IMPACTS REACTION RATES AND SELECTIVITY. INCREASING TEMPERATURE GENERALLY SPEEDS UP REACTIONS BUT CAN ALSO LEAD TO UNWANTED SIDE REACTIONS OR PRODUCT DEGRADATION. OPTIMIZATION INVOLVES FINDING THE SPECIFIC TEMPERATURE THAT BALANCES REACTION SPEED WITH DESIRED SELECTIVITY.

## **Q: WHAT IS DESIGN OF EXPERIMENTS (DoE) AND HOW IS IT USED IN OPTIMIZATION?**

A: DESIGN OF EXPERIMENTS (DoE) IS A STATISTICAL METHODOLOGY THAT ALLOWS FOR THE EFFICIENT STUDY OF MULTIPLE VARIABLES AND THEIR INTERACTIONS IN A CHEMICAL REACTION. IT HELPS IDENTIFY OPTIMAL CONDITIONS WITH FEWER EXPERIMENTS COMPARED TO TRADITIONAL ONE-VARIABLE-AT-A-TIME APPROACHES.

## **Q: CAN COMPUTATIONAL TOOLS HELP IN CHEMICAL SYNTHESIS OPTIMIZATION?**

A: YES, COMPUTATIONAL CHEMISTRY AND MOLECULAR MODELING CAN PREDICT REACTION PATHWAYS, ACTIVATION ENERGIES, AND THE INFLUENCE OF DIFFERENT PARAMETERS. CHEMINFORMATICS AND MACHINE LEARNING LEVERAGE DATA ANALYSIS TO PREDICT OPTIMAL CONDITIONS AND ACCELERATE THE OPTIMIZATION PROCESS.

## **Q: WHAT ARE THE ADVANTAGES OF USING FLOW CHEMISTRY FOR OPTIMIZATION?**

A: FLOW CHEMISTRY OFFERS BETTER CONTROL OVER REACTION PARAMETERS LIKE TEMPERATURE AND MIXING, IMPROVED HEAT AND MASS TRANSFER, ENHANCED SAFETY FOR HAZARDOUS REACTIONS, AND EASIER SCALABILITY COMPARED TO BATCH PROCESSES, MAKING IT ADVANTAGEOUS FOR OPTIMIZATION.

## **Q: HOW DOES GREEN CHEMISTRY INFLUENCE CHEMICAL SYNTHESIS OPTIMIZATION?**

A: GREEN CHEMISTRY PRINCIPLES GUIDE OPTIMIZATION TOWARDS MINIMIZING WASTE, USING LESS HAZARDOUS SUBSTANCES, REDUCING ENERGY CONSUMPTION, AND EMPLOYING SUSTAINABLE SOLVENTS, AIMING FOR PROCESSES THAT ARE BOTH EFFICIENT AND ENVIRONMENTALLY FRIENDLY.

## **Q: WHAT ROLE DOES ANALYTICAL INSTRUMENTATION PLAY IN OPTIMIZATION?**

A: ANALYTICAL INSTRUMENTS LIKE HPLC, GC, AND NMR ARE CRUCIAL FOR MONITORING REACTION PROGRESS, QUANTIFYING PRODUCT YIELD, AND ASSESSING PURITY. THIS DATA IS ESSENTIAL FOR EVALUATING THE EFFECTIVENESS OF DIFFERENT OPTIMIZATION STRATEGIES.

## **Q: WHAT ARE SOME COMMON CHALLENGES ENCOUNTERED DURING SYNTHESIS OPTIMIZATION?**

A: COMMON CHALLENGES INCLUDE DEALING WITH COMPLEX MULTI-STEP SYNTHESSES WHERE OPTIMIZING ONE STEP CAN AFFECT OTHERS, THE VAST NUMBER OF POTENTIAL VARIABLES TO EXPLORE, AND THE DIFFICULTIES IN SCALING UP OPTIMIZED LABORATORY CONDITIONS TO INDUSTRIAL LEVELS.

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